

Work Order ID 78948

78948

Page 1

January-17-12 2:49:51 PM

Item ID: D3443-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Weldment Assembly
 Start Date: 17/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3443	Rev C								

100 0.00
100 Large Fab
 Large Fab Memo 0.00
 Large Fab Weld assembly as per dwg D3443

(4) 12126-5

110 0.00
110 QC9- Inspect visual per QSI004- Fusion Welds
 QC Memo 0.00
 Quality Control

P/L 12.06.05 4x

120 0.00
120 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control

526606 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat		0.00							
Powder Coating	Memo								
	1-Mask holes as per dwg D3443								
	START TIME: 8:40								
	OVEN TEMPERATURE: 400 °F								
	FINISH TIME: 9:10								
140	QC3- Inspect Part Finish	0.00							
140									
QC		0.00							
Quality Control	Memo								
150	Small Fab	0.00							
150									
Small Fab		0.00							
Small Fab	Memo								
	Assemble bearing and ball plungers as per dwg D3443 using DT9518								
	Ensure bearing rotates smoothly								

4X ϕ M.F. 12/06/08
 H ϕ B.12.6 8.
 4 ϕ FF 12-06-11

W 121134

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

170	Identify as per dwg & Stock Location: <u>ST19</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

mf
12-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 78948

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Parent Item: D3443-041

D3443-041

Parent Item Name: Strut Weldment Assembly

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3443-1 Manufactured No

D3443-1

Lug

82 961 x 4

Location

Loc Qty

Loc Code

WA

12

78200

12

D3443-5 Manufactured No

D3443-5

Tubing

Location

Loc Qty

Loc Code

WA022

8

73625

8

WA030

14

78203

14

D3453-1 Manufactured No

D3453-1

Clevis

B80246 x 4

D3965-4 Manufactured No

D3965-4

Bearing, Spherical

Location

Loc Qty

Loc Code

ST078

4

71181

2

73614

2

ST079

20

78208

20

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Picklist Print

January-17-12 2:49:55 PM

Page 2

Work Order ID: 78948

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Parent Item: D3443-041

D3443-041

Parent Item Name: Strut Weldment Assembly

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

D3966-4-750

Manufactured No

100

Each

87.0000

2

8

D3966-4-750

Pin, Dowel

E2 12-6-5

Location

Loc Qty

Loc Code

ST079

87

73566

87

8.8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

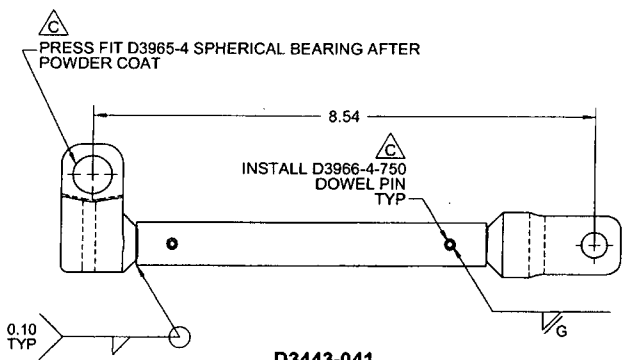
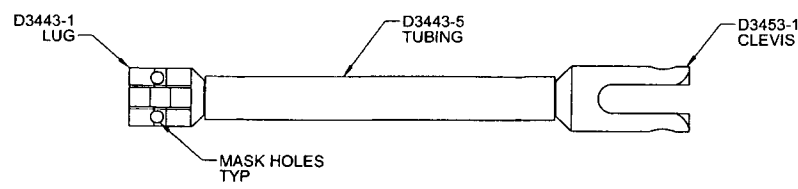
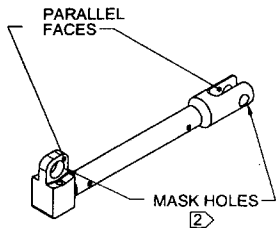
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

UNCLASSIFIED
SERIAL NO. 78948 M.L.J
12/01/17

RELEASED
09/08/25 M.P.

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.33 lbs
 - 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN AB-1, AB-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.218 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAU P/N (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE, & Ø 0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3443	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STRUT WELDMENT ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

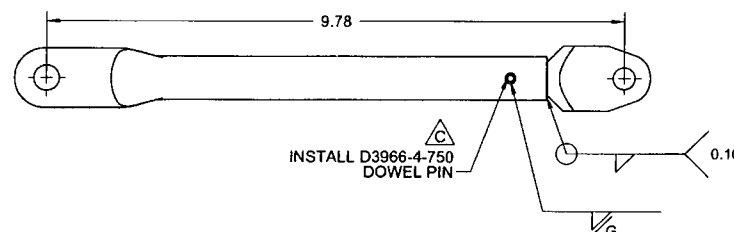
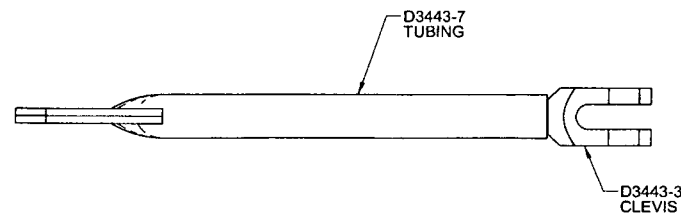
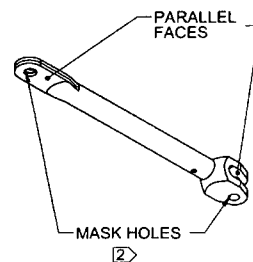
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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

RELEASED
09/06/25

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3443	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STRUT WELDMENT ASSEMBLY	NTS
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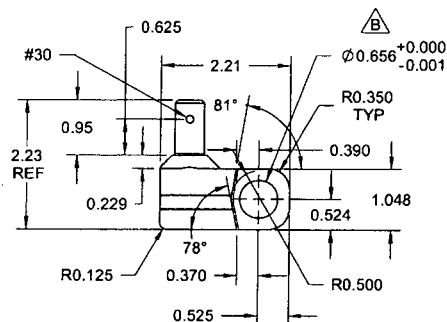
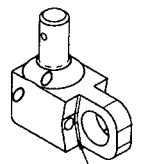
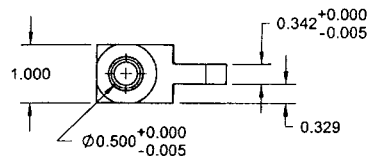
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

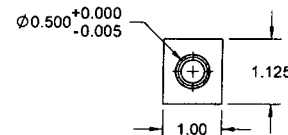
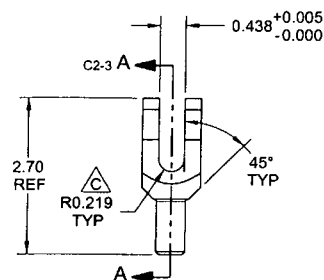
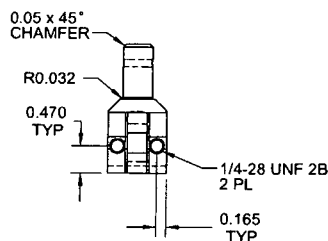
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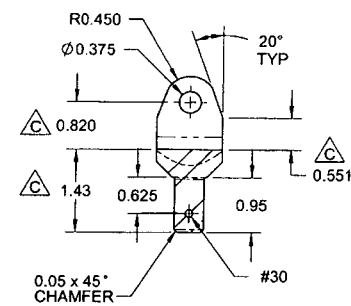
78948



D3443-1 LUG



D3443-3 CLEVIS






SECTION A-A C4-3

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

RELEASED
07/08/25/162

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY NTS	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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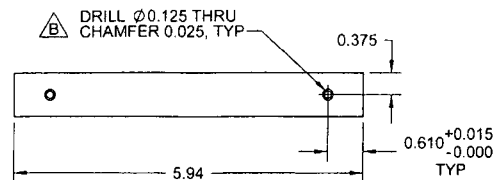
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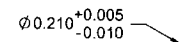
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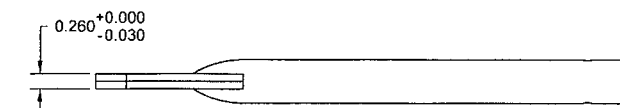
D3443-5 TUBING



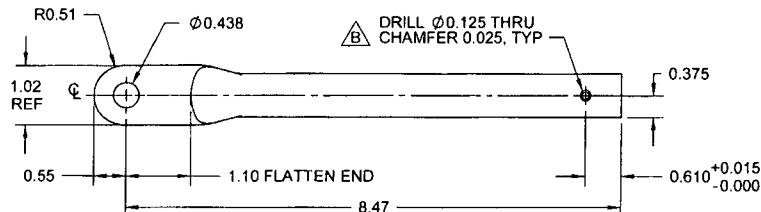
D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A






D3443-7 TUBING



D3443-5/7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

RELEASED
07/08/25 MJP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 4 OF 4
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DE APPR.		STRUT WELDMENT ASSEMBLY NTS	
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